

Date: Monday, 05/05/2008 4:12:26 PM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 205 SKIDTUBE "I" BEAM  
 Job Number : 39059  
 Estimate Number : 10346  
 P.O. Number :  
 This Issue : 05/05/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D2596  
 Drawing Number : D2596 REV D  
 Project Number : N/A  
 Drawing Revision : D  
 First Issue : / / Type : SKIDTUBES  
 Material :  
 Due Date : 10/05/2008 Qty: 4 Um: Each  
 Previous Run : 38951  
 Written By :  
 Checked & Approved By : JLD 08-5-05  
 Comment : Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D  
 M  
 Est Rev:E 07-07-09 Incorporated DEO 9183 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D25003100 Extr'n - I" Beam Web 4"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 Extrusion "I" Beam Web 4"

Pick;

Qty	Part Number	Description
1	D2500-3-100	Extrusion

Batch

B 33940

④ M 8-5-7

2.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

- 1- Cut D2500-3-100 to length: 99.5"
- 2- Use Jig DT8093 to drill pilot holes #30
- 3- Open to 0.630" diameter as per Dwg D2596
- 4- Deburr

M 8-5-7 ④

3.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid Etch and Alodine per QSI 005 4.1

M 8-5-7

④

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/05/07 (X4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: 205 SKIDTUBE "I" BEAM

Job Number: 39059

Part Number: D2596

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: L.G.

④ W 8-5-7

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/0978

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-05-08.

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

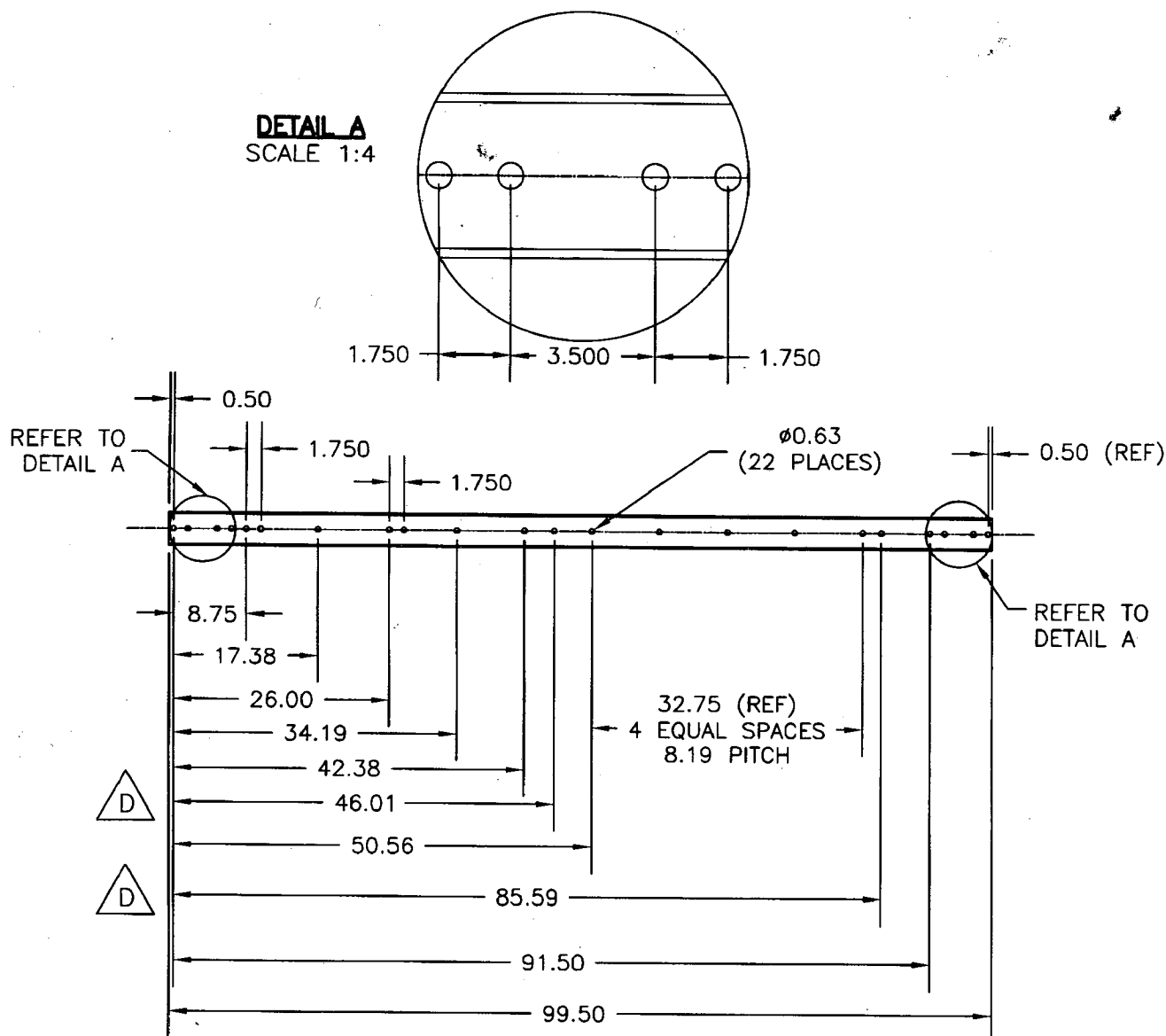
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



RELEASED  
07 DEC 68

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
84	AT	DRAWING NO.	D2596	REV. D
CHECKED	APPROVED	TITLE	205 WEB	SHEET 1 OF 1
DATE	07.04.17	SCALE	1:20	
A	96.09.16	NEW ISSUE		
B	97.07.23	Ø0.63 HOLE WAS Ø0.56		
C	98.09.14	INCORPORATED DEO 9097		
D	07.04.17	INCORPORATED DEO 9183		



**D2596 WEB**

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 39059

